

Work Order ID 68862



Page 1

Thursday, April 21, 2011 12:42:54 PM

Item ID: D3783-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Longitudinal Brace Assembly

Start Date: 4/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL 11/04/21 Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3783	Rev A

100	Pick Kit	0.00
Packaging	Memo	0.00
Packaging		

EP 11/05/26 (2)

110	Small Fab	0.00
Small Fab	Memo	0.00
Small Fab	1-assemble as per dwg D3783	

EP 11/05/26 (2)

120	QC5- Inspect part completeness to step on W/O	0.00
QC	Memo	0.00
Quality Control		

8 11/05/26

(72)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: 249 Memo	0.00 0.00						11/5/26 Q25	
140 QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 0.00						11/5/30 Q25 CMF 11-05-27	

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 12:42:51 PM

Page 1

Work Order ID: 68862

Parent Item: D3783-043

Parent Item Name: Longitudinal Brace Assembly




Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-13A  Bolt		Purchased	No			110	Each	80.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MEZZ		80							
				116003		80							
AN960JD516  Washer	NAS1149D0563J	Purchased	No			110	Each	0.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST243		9							
				64766		9							
D3765-1  Clevis		Manufactured	No			110	Each	9.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST251A		20							
				65062		10							
				66892		10							
D3769-3  Tube		Manufactured	No			110	Each	20.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST251A		20							
				65062		10							
				66892		10							

4 M117291 (42)

4/21/05/20

4/21/05/20

4/21/05/20

4/21/05/20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, April 21, 2011 12:42:51 PM

Work Order ID: 68862



Parent Item: D3783-043



Parent Item Name: Longitudinal Brace Assembly

Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

1,194.000

1

2



Nut



Handwritten signature
4/21/05/26

Location

Loc Qty

Loc Code

ST300

1194

116105

434

116548

260

117441

500

2

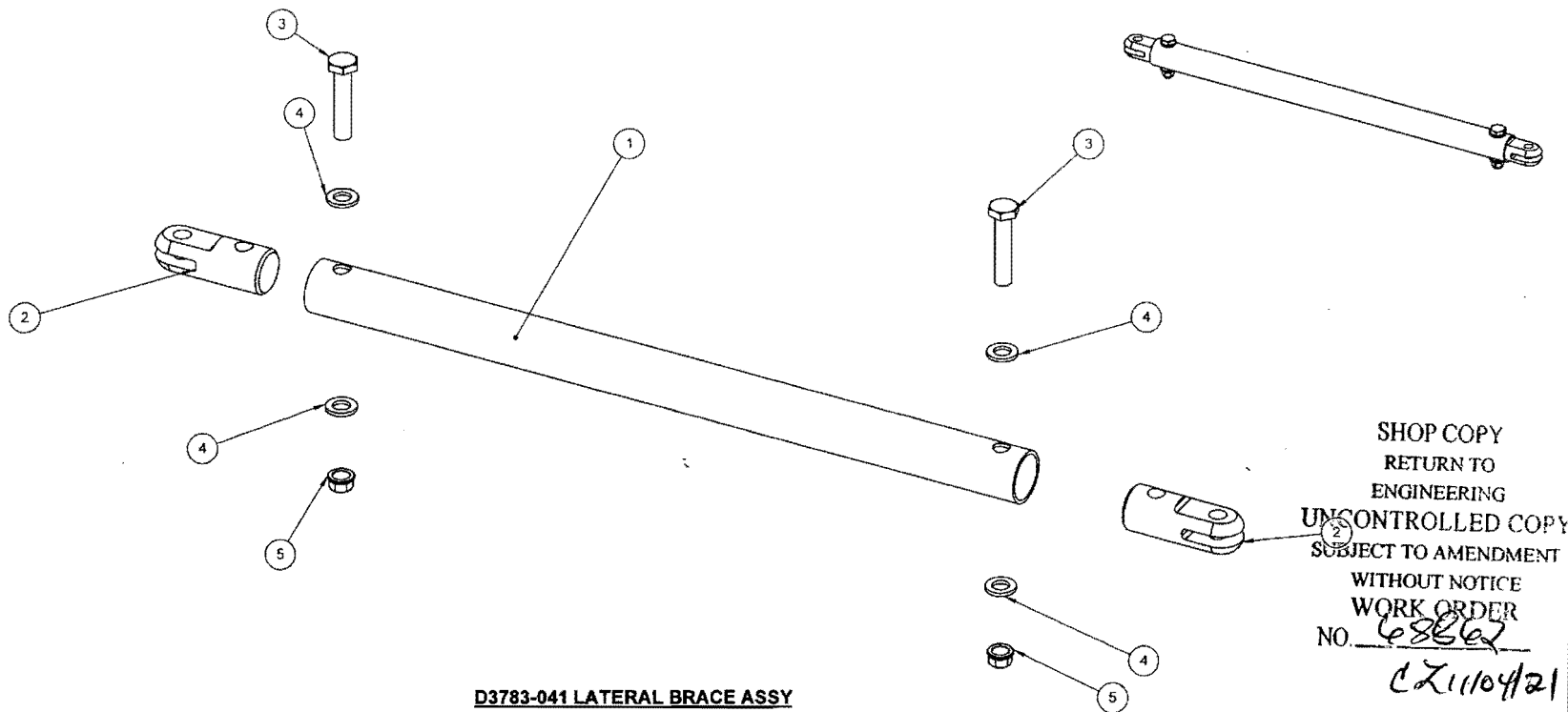
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-041 LATERAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3789-1	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN980JD516)	4
5	MS21042L5	NUT	2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.52 lbs

RELEASED
08/06/04

A		NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 3	
DRAWN	HS				
CHECKED	HS	DRAWING NO.		REV. A	
MFG. APPR.	HS	D3783		SCALE	
APPROVED	HS	TITLE		NTS	
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DATE		08.06.04		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

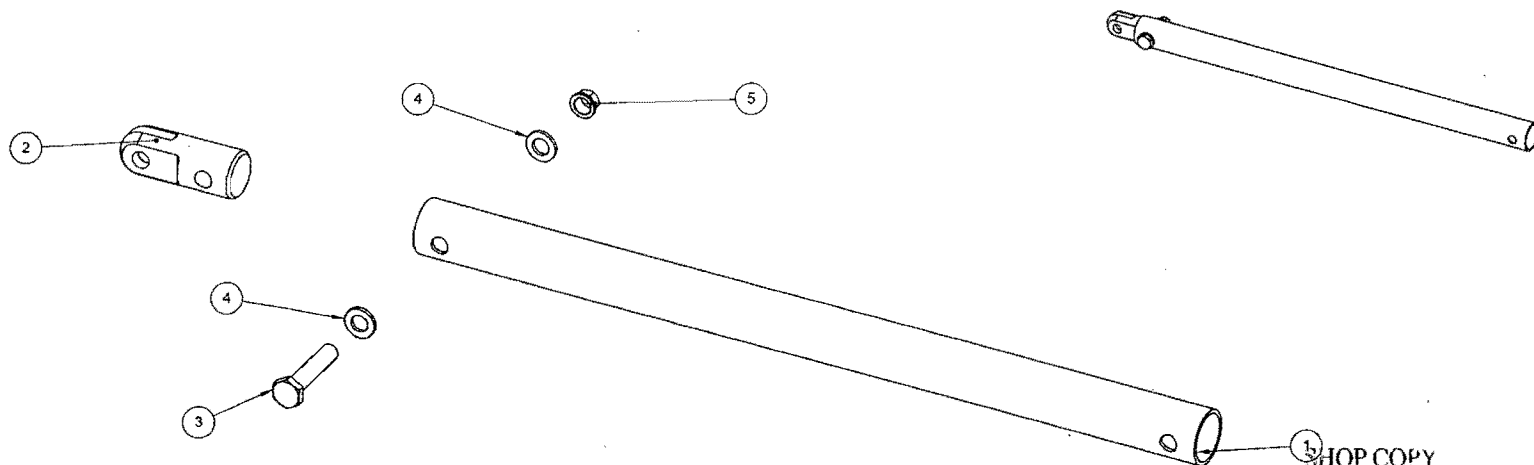
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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 WORK ORDER
 NO. 68662

D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

RELEASED
 08-06-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. D3783	REV. A
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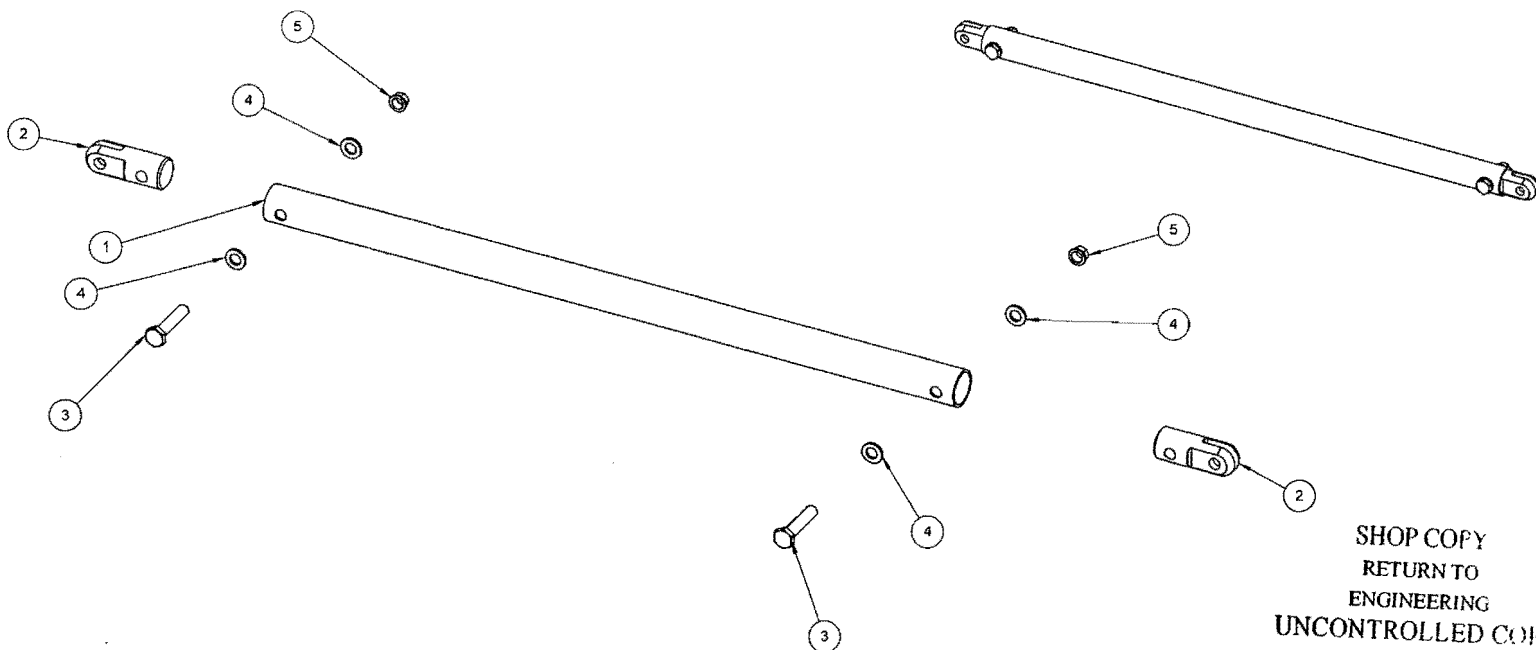
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3789-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.63 lbs

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WORK ORDER
NO. 68862

RELEASED
08-06-14

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APPROVED		TITLE BRACE ASSEMBLY	SCALE NTS
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DATE	08.06.04		

W/O:		WORK ORDER CHANGES					
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